

Date: Fri, 09/05/2008 1:46:24 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SHORT STEP ASSEMBLY HIGH SKID RH
Job Number :	39165		
Estimate Number :	10720		
P.O. Number :		Part Number :	D350591214
This Issue :	09/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3078 REV A
First Issue :	1/1	Project Number :	N/A
Previous Run :	38538	Drawing Revision :	A
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	30/05/2008
Written By :		Qty:	6 Um: Each
Checked & Approved By :	JLD 08.5.09		
Comment :	Est Rev:B 05.10.14 Modified step 10 KJ/EC Est Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM Est Rev:C 06-06-27 Revised as per DSI9340 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-214 CHG002

08/06/08 08.5.20 JLD

2.0	D2622120C	Step Extrusion
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Comment: Qty.: 0.5000 Each(s)/Unit Total: 2.5000 Each(s)

Pick:

Qty Part Number

Description Batch

.5 D2622-120

Extrusion

831754

08.06.02 6

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078

2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.

3-Deburr

08.06.02 6
 08-06-02 6
 08-06-02 6

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08/06/02 6

W/O:		WORK ORDER CHANGES					
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Job Number: 39165

Part Number: D350591214

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3067-1

End Plate

338926

SE 08.06.02 6

6.0

D30631

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3063-1

Support

335691

SE 08.06.02 6

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3078

A/R Aluminum Rod m106834

3-Grind End Plate flush

SE 08.06.02 6
SE 08.06.02 6
SE 08-06-03 6

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08.06.05 (6)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/05 (6/14)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m/2V

08/06/06 (6)

W/O:		WORK ORDER CHANGES					
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Job Number: 39165

Part Number: D350591214

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JP 08.06.11

12.0

D3065041

Step Leg Assembly Hi



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3065-041

Step Leg Assy

B35626

JP 08.06.11

13.0

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3066-1

Spacer

B38925 = 10
B39261 = 2

JP 08.06.11

14.0

MS20600AD4W4

Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W4

Rivet

M 108077

JP 08.06.11

15.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Rivet Leg Assembly as per Dwg D3078.

JP 08.06.11

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/6/11 *(+6 RH)*

17.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3067-1

End Plate

B38926

JP 08.06.11

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Drawing Name: SHORT STEP ASSEMBLY HIGH SKID RH

Job Number: 39165

Part Number: D350591214

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 02

3-Weld Aft End Plate as per QSI 004 & Dwg D3078

A/R Aluminum Rod

4-Grind End Plate flush

Handwritten notes:
ESP 08.06.11
ESP 08.06.11
ESP 08.06.11
M 106834

Handwritten note: 08.06.12

19.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten note: PD 08-06-12

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten note: 08/06/12 (6R10)

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Chemical conversion

Handwritten note: 08/06/12

22.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Handwritten notes:
9:00 am
320 °F
9:30 a.m.

Handwritten note: M.D 08/06/12

23.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3078 and QSI 005 4.4

Handwritten note: M 107892

Handwritten note: 08/06/12

W/O:		WORK ORDER CHANGES					
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Job Number: 39165

Part Number: D350591214

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

8/6/16 (x6 RH)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

26.0

D22303

Lug



6X

Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-3

Clamp 39919

54

27.0

D22301

Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-1

Clamp 39315

54

28.0

D2732

Rubber Extrusion



Comment: Qty.: 1.0000 f(s)/Unit Total : 5.0000 f(s)

Rubber Extrusion

4 X 3"

Batch: 37632

54

29.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 3.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2856-400(7.2")

Abrasion Strip 36161

8/6/10

54

W/O:		WORK ORDER CHANGES					
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Job Number: 39165

Part Number: D350591214

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

AN335A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A

Bolt

106993

sc

31.0

AN411A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total: 30.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 AN4-11A

Bolt

106605

sc

32.0

AN413A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bolt

Batch: M103363

107534

sc

33.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10

Washer

108077

sc

34.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416

Washer

107939

sc

35.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3

Nut (or -3)

107644

8/6/10

sc

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 39165

Part Number: D350591214

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

MS21042L4

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS21042L4

Nut (or -4)

107478

8/6/10

50

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/06/18 (6 Rte)

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-214

Location:

PPP Rev:

Rev D

8/06/18



39.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/19

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



h 08-06-18

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



RELEASED
02.09.20

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3078	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 39165

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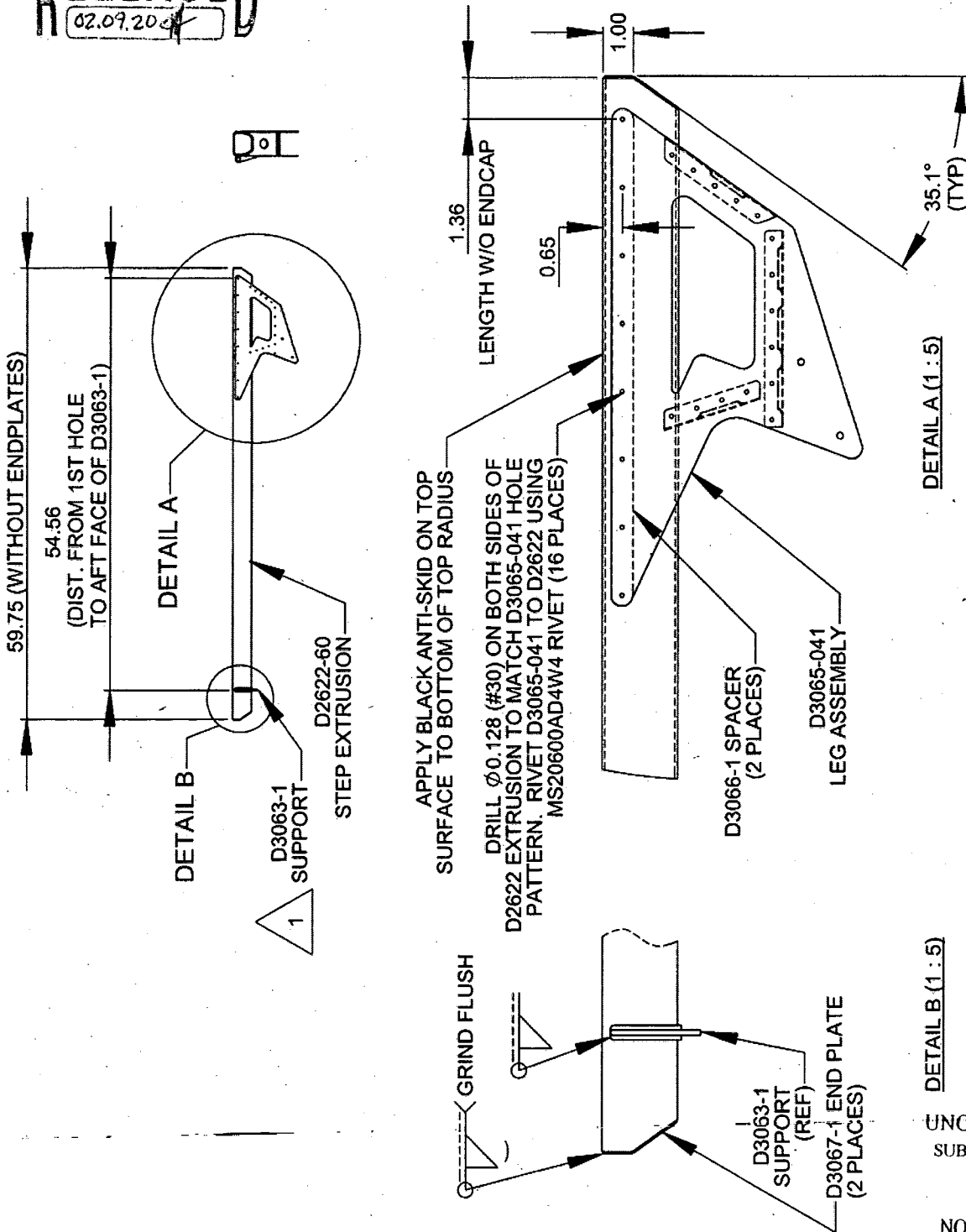
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NOTE: Date & initial all entries

DART

DESIGN <i>up</i>	DRAWN BY <i>up</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>up</i>	APPROVED <i>up</i>	DRAWING NO. D3078	REV. A SHEET 2 OF 2
DATE 02.09.11	TITLE STEP ASSEMBLY, HI SHORT		SCALE 1:20

RELEASED
02.09.2011

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